Work Orde Monday, Decemb												,	Page 1	
Item ID: Revision ID:	D4110-2				Accept					Setup S	= tart			-
Item Name:	Door Doubler,	RH								5	Stop			
Start Date: Required Date: Reference:	12/2/2010 12/15/2010	Start Qty: (Req'd Qty: (1800		Cust Item I Customer:	D:		٠					
	Process Pla	n:	<i>,</i>	Date: <i>D-13-4</i>	Tooling: SPC (Y/N):		nte:		, J		Start Stop			
Sequence ID/ Work Center ID)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	-
Draw Nbr	Revi	ision Nbr												
D4110	Α													
100 			,		0.00				1R	61-01	-17			
Waterjet		Mei	mo		0.00				_ 10_	<u> </u>				
FLOW CNC Waterje 304 . બ્લેડે	t	Dw _i Prog	g Rev:_ g Rev:_		0-1***							1	6	
110		OC2 Inspect	uta off :	machina EAL/EAID	0.00									

0.00

Memo

Quality Control

1B10-13-M

Work Order ID 64355

Monday, December 06, 2010 3:24:28 PM



Page 2

Item ID:

D4110-2

QC:

Accept

Setup Start

Stop



Revision ID:

Item Name:

Door Doubler, RH

Start Date:

12/2/2010 Start Qty: 6.00 **Required Date: 12/15/2010**

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date:

Start Stop



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

Run

130

Small Fab

Small Fab

Memo

1- C'sink holes as per dwg

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

000 Siolizkel

Work Order ID 64355

Monday, December 06, 2010 3:24:28 PM



Page 3

Item ID:

D4110-2

Accept

Setup Start

Stop



Revision ID:

Item Name:

Door Doubler, RH

Start Date: 12/2/2010 **Required Date: 12/15/2010**

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:_ **Tooling:**

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

150

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

Run Hours 0.00

Set Up/

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10/12/21_12/ MF-12-21

Picklist Print

Monday, December 06, 2010 3:24:32 PM

Work Order ID: 64355

D4110-2

Palent Item Name: Door Doubler, R.1



Start Date: 12/2:2010

Required Date: 12/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Parent Item:

IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	124.0000	0.0318	0.200842			-
											1310-	12-1	77

304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT	124		
111323	0		
115953	124		114,643

Page 1

DART AEROSPACE LTD	Work Order:	64355 1
Description: DOOR Doubled R.H.	Part Number:	D4110-2
Inspection Dwg: D410 -2 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

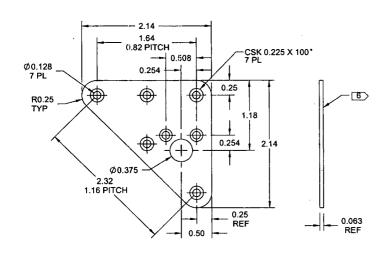
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7.14 1/2 200 21/4 1/2 1/2 1/2 1/2 1/2 1/2 1/2 1/2 1/2 1/2			l .	8		U	
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754 47010 .74 6 V .508 47010 .507 7 V .509 47010 .507 7 V .509 47010 .507 7 V .509 47020 .1.191 7 V .509 47020 .1.191 7 V .509 47020 .544 8		,	.817	×		ν	
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1.18			i	>		V	
1.18 4 .30 1.191 7 V .32 24 4 .33 2.141 8 V .34 4 .33 2.141 8 V .50 4 .33 2.34 8 V .33 2.34 8 V .33 1.16 2 2 V .116 4 .33 1.179 2 V .663 4 .30 .30 .38 1 V			.254	Ħ		V	
354 4/ 30 364 8 V 3.14 4/ 30 3.141 8 V .50 1/ 30 .504 8 V 3.33 4/ 30 3.319 8 V 1.16 4/ 30 1.159 6 V .663 4/ 30 .058 1 V			1.191	7		V	
2.14 42 .30 2.141 8 V .50 42 .30 .504 8 V 2.33 42 .33 2.319 8 V 1.16 42 .32 1.159 = V .663 47 .00 .058 1 V	i ·	1.4	.744	B		V	
.50 1/ .30 .504 8 V 233 1/ .33 2.319 8 V 1.16 1/ .33 1.159 2 V .633 1/ .00 .058 2 V		11	2.141	চ		V	
2.33 *L .030 2.319 & V 1.16 *L .030 1.179 & V .063 *L .000 .058 1 V	i	1.4		8		1	
1.16 4- 30 1.19 & V 1.63 4- 00 .058 2				4	·		
1063 41au 1058 }		T		2			
			,058	2		V	· .

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Measured by:	1B	Audited by:	9	Prototype Approval:
Date:	10-12-17	Date:	10/12/17	Date:
Date.	10-19 11		(011 011)	Boyleed by Approv

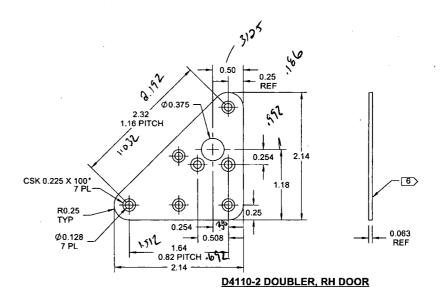
1	5	Data =	Change		Revised by	Approved
	Rev	Date	Change	· · · · · · · · · · · · · · · · · · ·	KJ/JLM	
	Α		New issue		1000 Civi	<u> </u>

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 0.44355 0.44355 **D4110-1 DOUBLER, LH DOOR** D4110-3 DOUBLER, SILL **D4110-2 DOUBLER, RH DOOR** A NEW ISSUE 10.07.20 DESCRIPTION REV: BY DATE DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. CHECKED REV. A D4110 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE DOUBLER DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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ulo 64355



D4110-1 DOUBLER, LH DOOR



NOTES: 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA

2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSP	ACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	13	DRAWING NO.	REV. A			
MFG. APPR.	- M	D4110	SHEET 2 OF 3			
APPROVED	WH	TITLE	SCALE			
DE APPR.	-#	DOUBLER	NTS			
DATE 10.0	7.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DODARDY IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OF COMMANDACTION TO ANY OTHER PURSON WITHOUT WHITTIEM PERMISSION FROM NOT AEROSPACE ITD.				

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7 3 1 ub (4355 D Ç SYMM R2.10 Ø0.375 -CSK 0.225 X 100° 2 PL R0.38 - 0.75 - 0.76 0.19 0.254 0.06 2.88 2.31 <u>6</u> 0.91 PITCH R0.25 0.254 Ø0.128 0.063 TYP 15 PL 0.508 - 0.25 4.50 1.13 PITCH 5.00 D4110-3 DOUBLER, SILL NOTES: 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
7) WEIGHT: 0.21 lbs DRAWING NO. . CHECKED REV. A D4110 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE **DOUBLER** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND DEMOCRATIVE AND IS SUPPLED ON THE DEMOCS CONCERNMENT AND THE PERSON WITHOUT TO BE USED FOR MAY PURPOSE OF COPPED OF COMMENCATED TO ANY OTHER PERSON WITHOUT WAS TITLE PERSONS FOR DART AROSPACE LTD. DATE 10.07.20 8 3